USER'S MANUAL

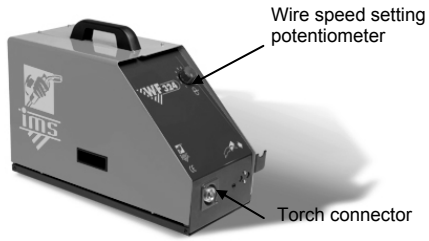
Declaration of conformity :
These devices have been designed following the European standards :
- Directive Low Tension 73/23 CEE 19/02/1973 (decree nr 95-1081 03/10/1995)
- Directive Electromagnetic Compatibility 89/336 CEE 03/05/1989.
This conformity was established in respect to European standards EN 50199 of 1995 (CEM directive), EN60974-1 of 1998 and amendments A1 of 2000 and A2 of 2003.

IMS WIRE FEEDER WF 324

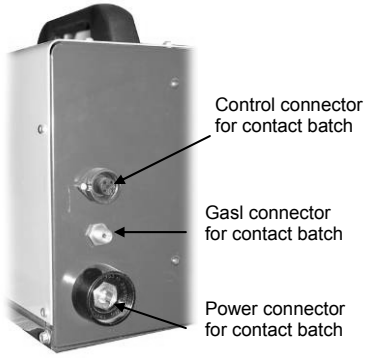
I / DESCRIPTION

The IMS wire feeder is suitable on IMS MIG PRO 41/35 MIG welding unit.
To be useful, IMS wire feeder has to be connected to IMS MIG PRO 41/35 via a contact batch.
IMS WF 324 wire feeder can be used with rolls whose diameters can reach 300mm.

Front panel IMS WF 324



Rear panel IMS WF 324

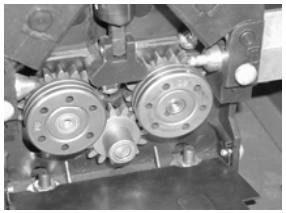


II / *PREPARATION*

Settings/choice of rollers
IMS wire feeder is delivered with the following original equipment :
IMS WF 324 : double slot roller 0.8/1.0mm for steel

However, the rollers have to be chosen following the diameter and type of the wire to be used => reverse the slot if needed (see chart here below).

Double slot roller	Reference
0.6/0.8mm	042353
0.8/1.0mm	042360
0.8/1.0mm alu	042377
0.9/1.2mm no gas	042407
1.2/1.6mm	042384
1.2/1.6mm alu	042391



Connection of the wire feeder to the MIG via the contact batch

- Connect the power cable and the control cable of the MIG contact batch at the rear of the wire feeder. The power cable has to be rotated of 90°.

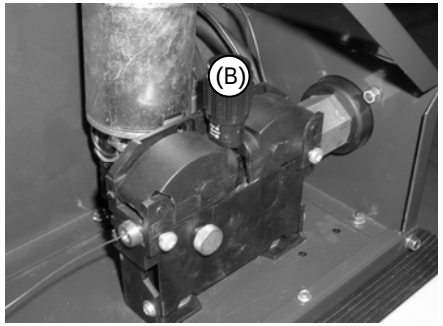
Installation of the torch

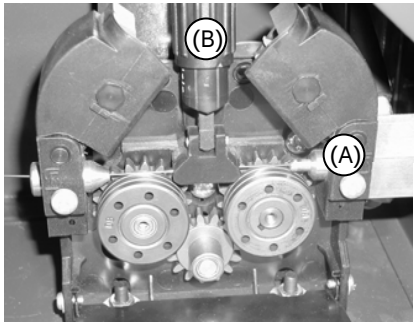
- Connect the torch to the wire feeder.

Installation of the reel

- Open the wire feeder slot,
- Remove the nut from the reel support,
- Set the reel on its support and insure that it is well locked by the pin and put the nut back in place,
- For a use with steel wire, place the capillar (A),
- For a use with aluminium wire, do not use capillar in the European connection but a Teflon sheath (special aluminium) that has to come to the moto-wire feeder,
- Set the wire at the entrance of the moto-wire feeder,
- Untight the tighting lever (B),
- Close the panel of the moto-wire feeder,
- Push on the "AVANCE FIL" of the MIG and on the torch trigger (gas closed),
- Slowly tight the tighting lever (B) until the motor starts to drive the wire.

III / USE





- Select the position of the wire feeder on your MIG,
- Set your MIG as usual (current, 2T, 4T, etc.),
- Then set the wire speed thanks to the wire speed setting potentiometer of the wire feeder.

IV / OUR ADVICE

- Let the ventilation holes free to let the air coming in and out.
- The maintenance must only be done by a qualified person.

V / SECURITY

Arc welding can be dangerous and can lead to serious injuries, which can be fatal. Protect yourself and protect the others.
Take precautions against :

- Arc emissions : Protect yourself thanks to an electronic welding helmet in compliance with EN 175, supply with filters in compliance with EN 169 or EN 379.
- Rain, steam, humidity : Select a clean environment to use your product (degree of pollution ≤ 3), on the even place and put the machine at least one meter from the part to be welded.
- Electric shock : This unit has to be used on a single-phase power supply, with 3 wires, with neutral connected to the earth. Do not touch the parts under voltage. Check that the supply system is well adapted to the unit.
- Falls : Do not carry the unit over the people or things.
- Burns : Wear protective or fire-proof clothing (cotton, overalls or jeans).

Work with welder gloves and a fire-proof apron.
Protect the others by installing non flammable protection walls, or prevent the others to not look at the arc and to keep a sufficient distance

- Fire risks : Suppress all flammable products from the working area. Do not work near flammable gas.
- Smokes : Do not inhale gas or welding smokes, use adapted extractors

Do not use this unit near people using Pacemaker.
Do not use the unit to defrost tubing.
Handle the gas bottle with care. Indeed, there are risks if the bottle or the bottle valve are damaged.

VI / ANOMALIES, CAUSES, REMEDIES

Anomalies	Causes	Remedies
During the starting, there is a spark between the electrode and the filler metal stick.	There is an accumulation of filings on the roller of the moto-wire feeder.	Clean the moto-wire feeder and the rollers with an air gun.
No starting.	No gas	Open the gas.
No starting.	No gas	Gas bottle is empty.
The wire speed is not constant.	The wire is spinning on the roller.	Untight the break of the wire reel.
	The torch is bended, which breaks the exit of the wire.	Check the torch.